

Date: Tuesday, 03/02/2009 11:00:04 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOP PANNEL ASS'Y
Job Number : 45448	
Estimate Number : 13067	
P.O. Number :	Part Number : D3650041
This Issue : 03/02/2009 S.O. No. :	Drawing Number : D3650 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 45306	Material :
Written By :	Due Date : 10/02/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JUL 09 02 03</u>	
Comment : Est Rev:A New Issue 07-11-12 EC verified by: DD Est Rev:B Ecn 1113P 08-01-22 DD verified by:EC Est Rev:C Ecn1162 08-04-02 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 pick kit

2.0	D36501	Aft Panel
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 AFT PANEL
 batch B 44672

SB 09/02/04

3.0	D36503	Center Panel
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 CENTER PANEL
 batch B 42096

SB 09/02/04

4.0	D36505	Fwd Panel
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 CENTER PANEL
 batch B 44673

SB 09/02/04

5.0	AN3C3A	Bolt
-----	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Bolt
 batch M 110915

SB 09/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/02/2009 11:00:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANNEL ASS'Y

Job Number: 45448

Part Number: D3650041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 8.0000 EACH(s)/Unit Total: 16.0000 EACH(s)

WASHER

batch M1109 145

SB 09/02/04

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3650

2- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealant

as per dwg D3650

Batch: M110624

FF 09/02/04

(2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/04

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

D 3648-041

B. 45449 SB 09/02/04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

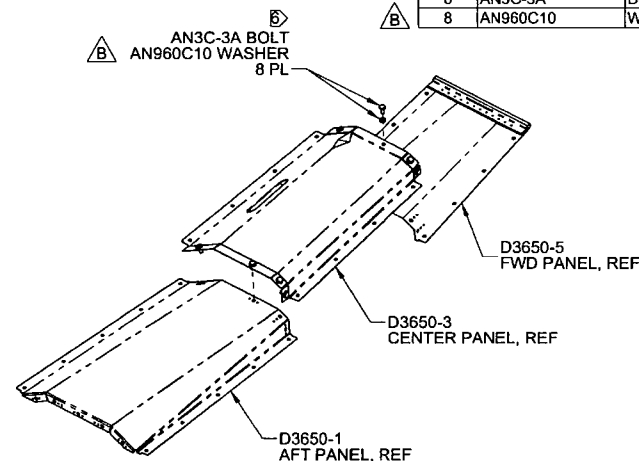
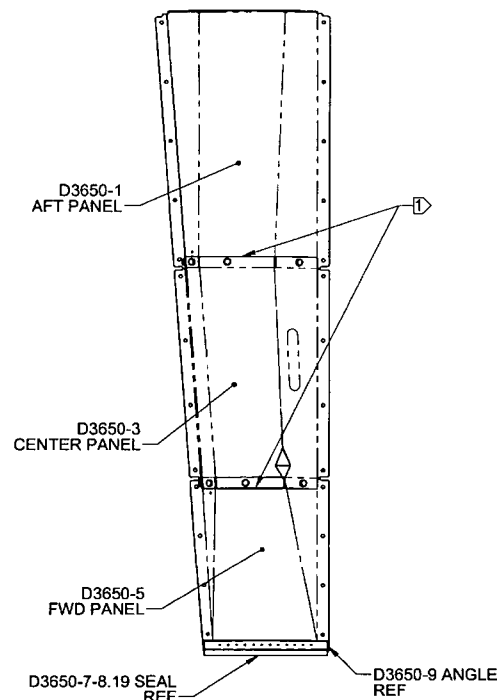
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



RELEASE
11-17-14

D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4MS WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3650** REV. C
SHEET 1 OF 9

TITLE **TOP PANEL ASSEMBLY** SCALE 1:8

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8 7 6 5 4 3 2 1

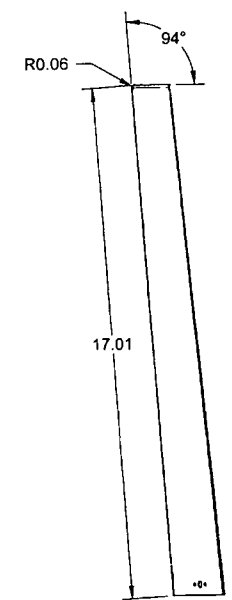
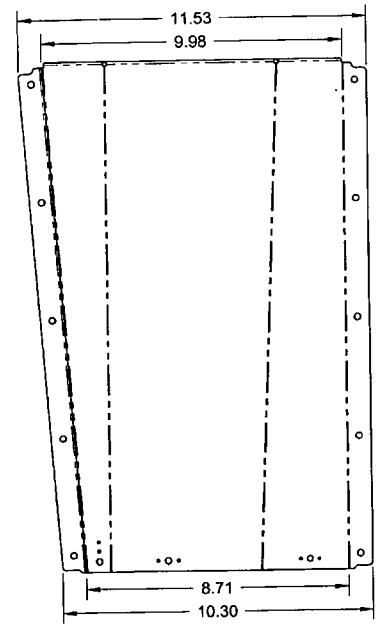
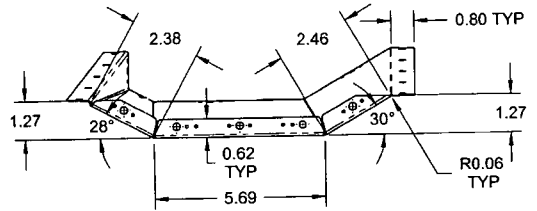
QTY	PART NUMBER	DESCRIPTION
-1		
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

MS21060-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
6 PL

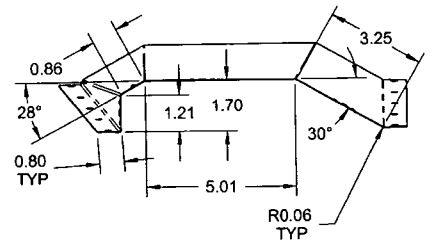
D3650-1B
AFT PANEL BENT PART

MS21062-3K NUTPLATE
MS20427M3-3 RIVET, 2PL
3 PL

D3650-1 AFT PANEL



D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)



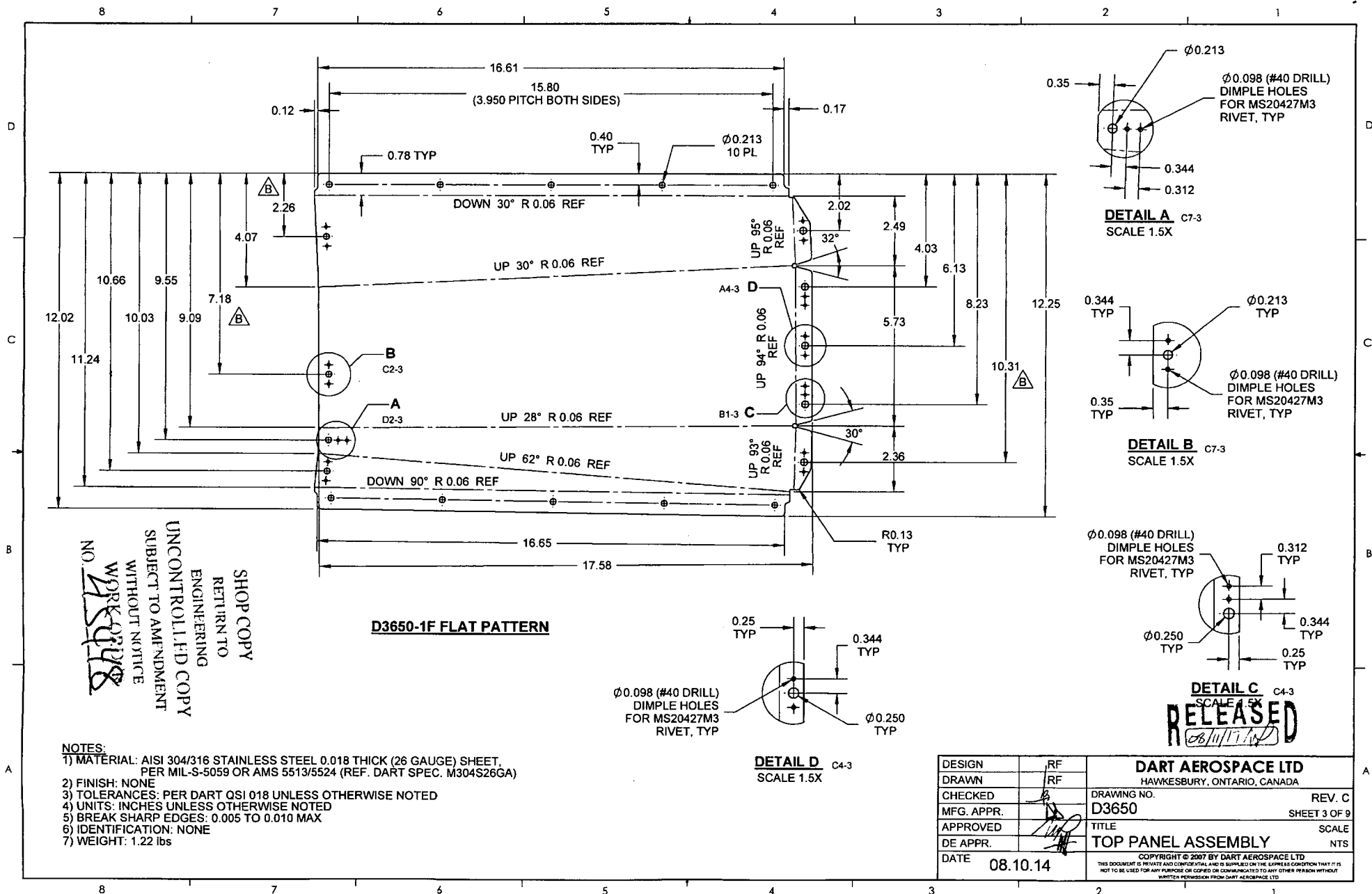
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- NOTES:
- 1) FINISH: NONE
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE
 - 6) WEIGHT: 1.3 lbs

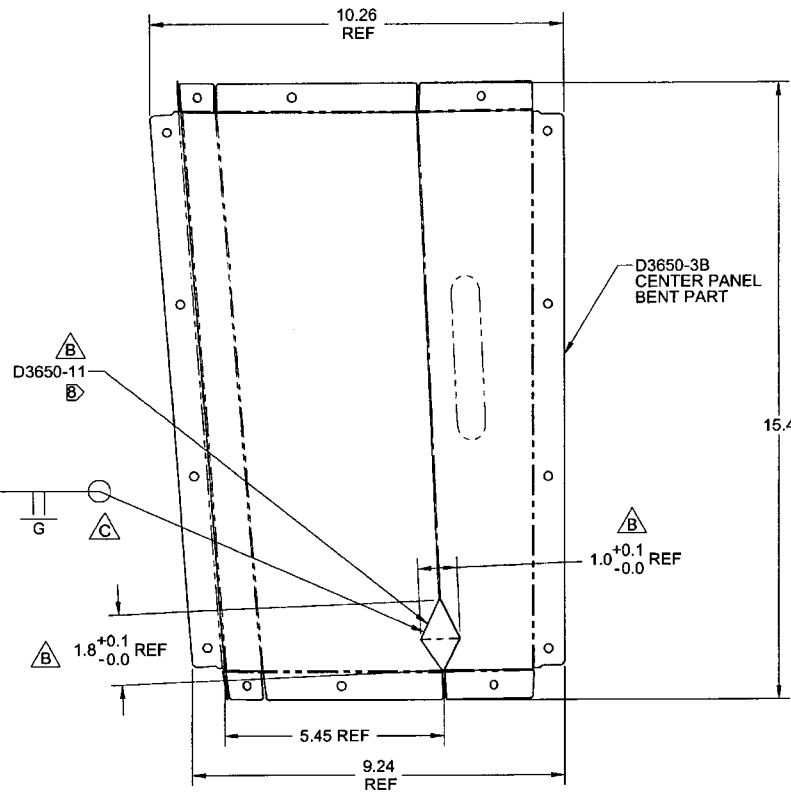
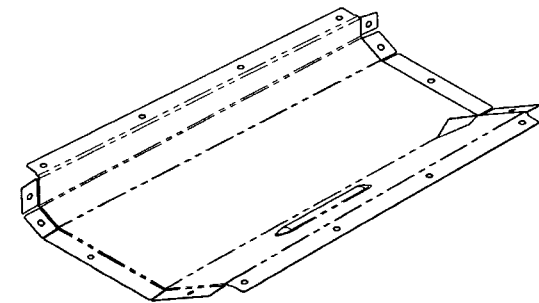
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06/11/17 JWB

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3650	REV. C
MFG. APPR.		TITLE TOP PANEL ASSEMBLY	SCALE
APPROVED			NTS
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DATE	08.10.14		

8 7 6 5 4 3 2 1



QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE



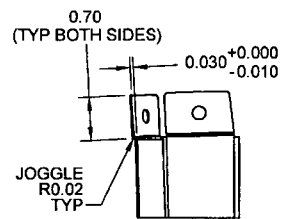
D3650-3 CENTER PANEL
(LOOKING FROM OUT SIDE SURFACE)

RELEASED
08-11-17

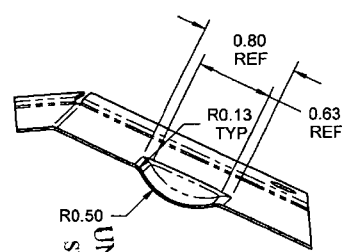
- NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.0 lb
 - 8) TRIM D3650-11 TO FIT AS REQUIRED

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MFG. APPR.		D3650	SHEET 4 OF 9
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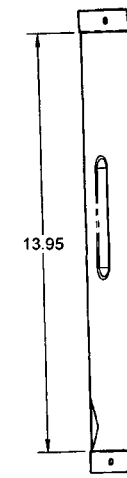
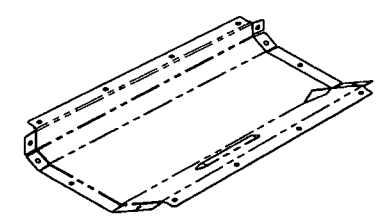
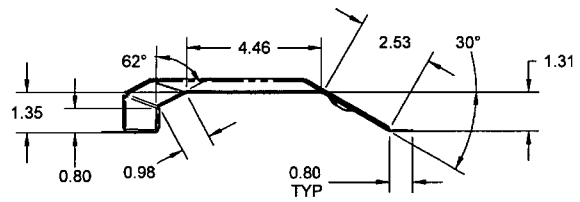
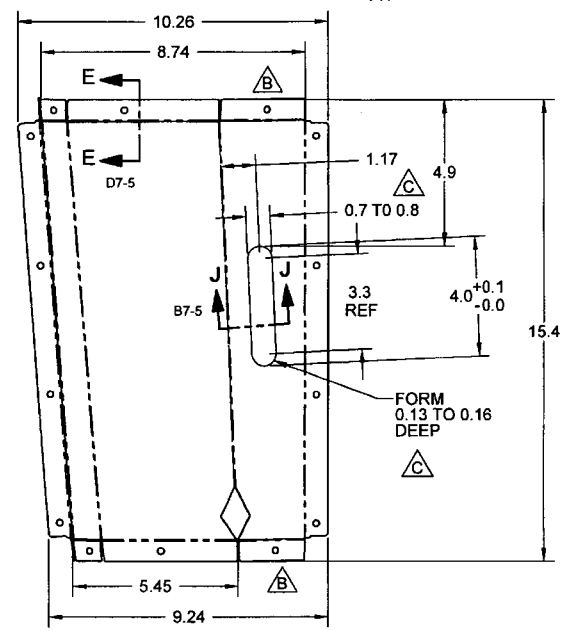
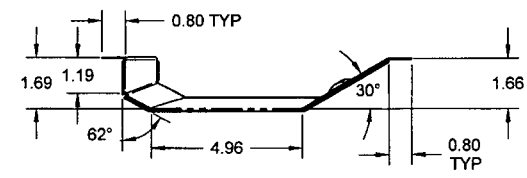
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SECTION E-E D5-5
SCALE 2X



SECTION J-J C5-5
SCALE 3.5X



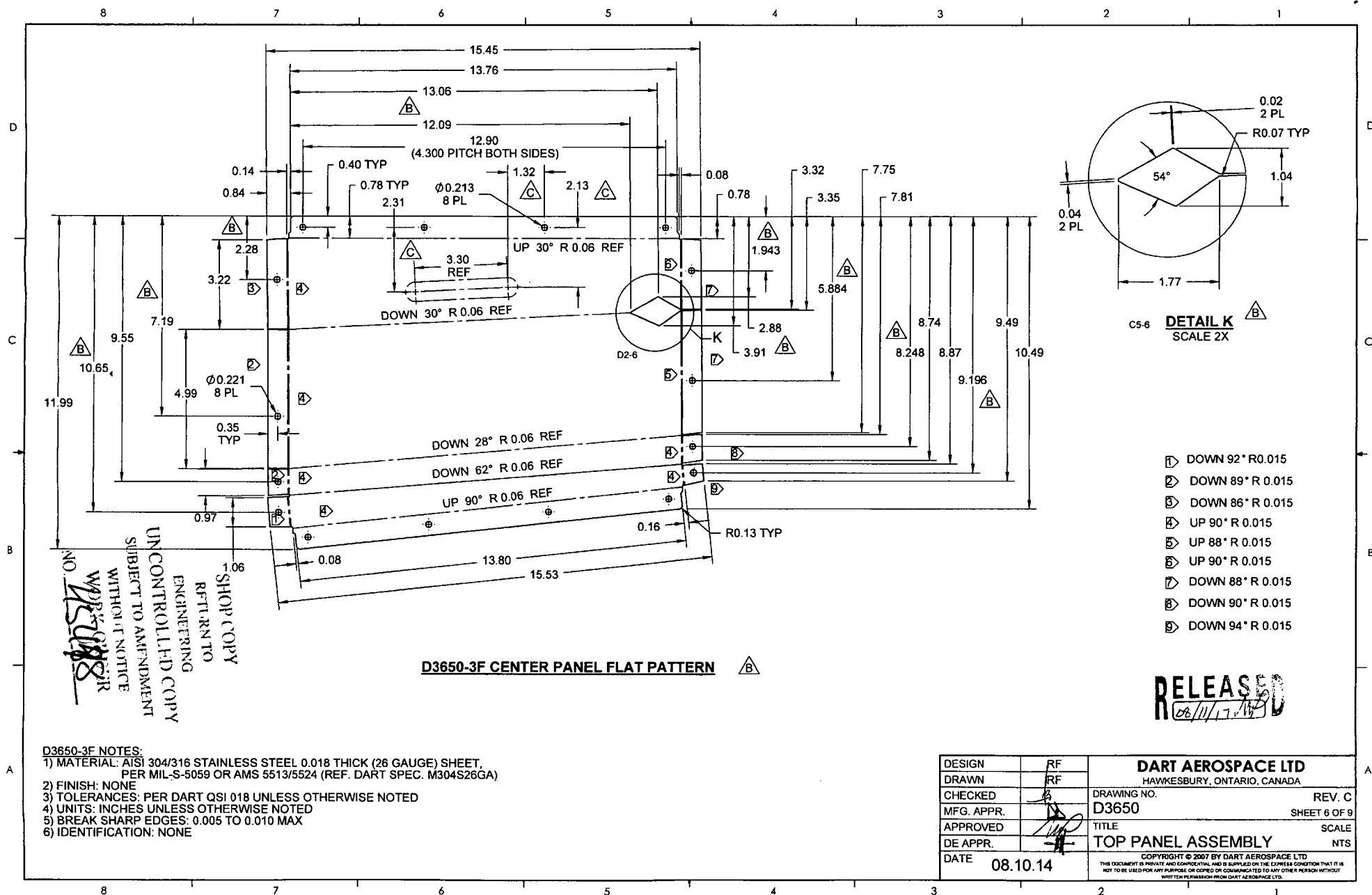
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- NOTES:**
 1) FINISH: NONE
 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 5) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

RELEASED
6/11/17 MJD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3650	REV. C
MFG. APPR.			SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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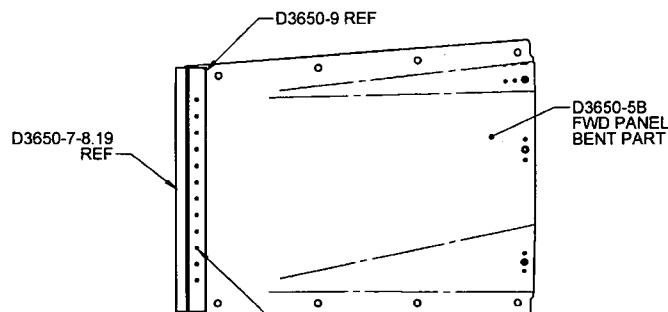
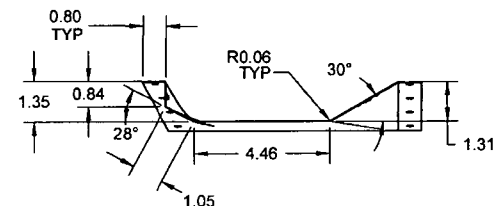
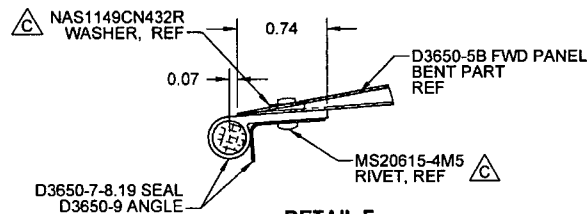


RELEASE
08/11/17

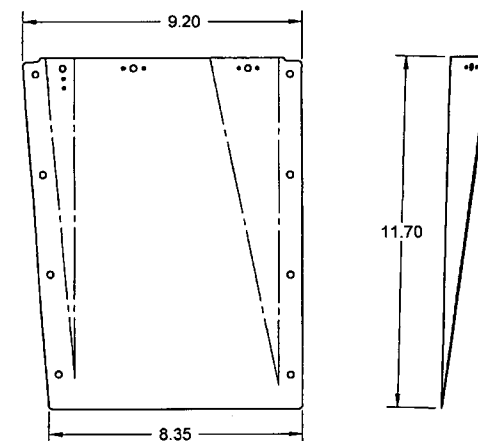
MS21062-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
2 PL

MS21060-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
2 PL

D3650-5B
FWD PANEL
BENT PART
REF



CENTRE D3650-7/-9 ON D3650-5B &
TRANSFER Ø0.129 (#30 DRILL) HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
MS20615-4M5 RIVET
NAS1149CN432R WASHER
12 PL



D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

RELEASED
26/11/17

PART LIST

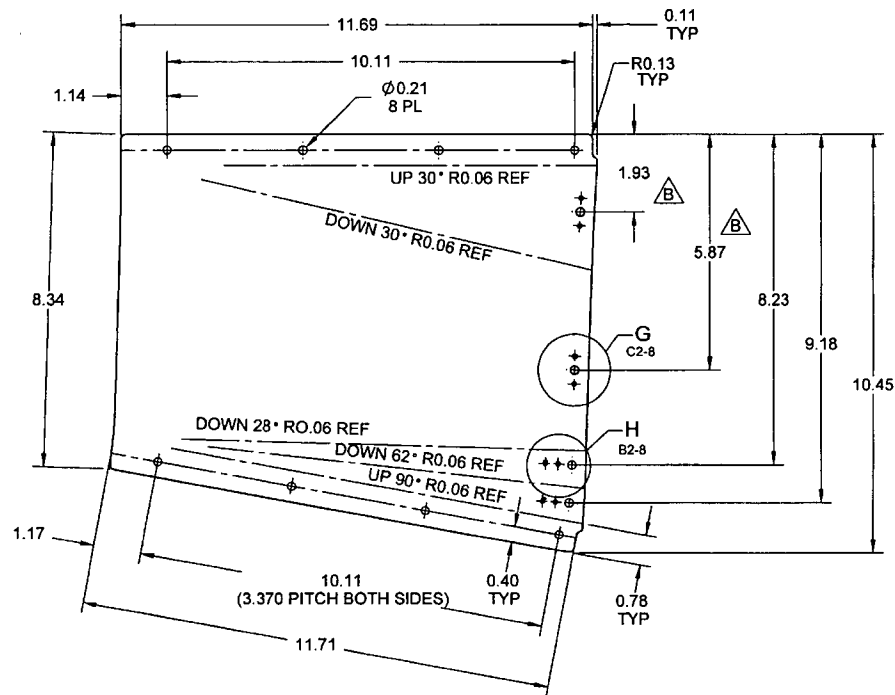
QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

NOTES:

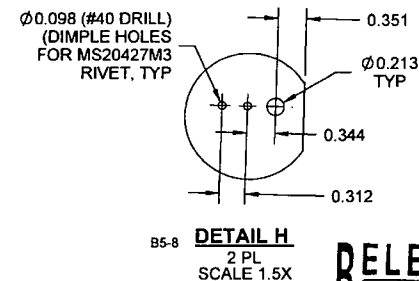
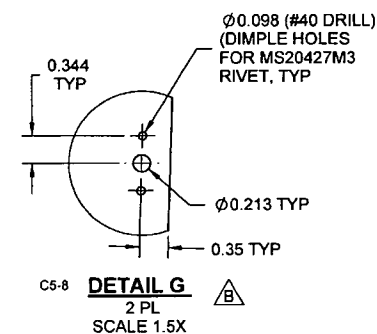
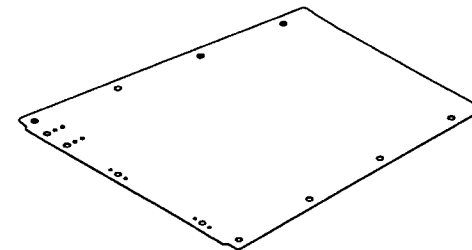
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lbs

D3650-5 FWD PANEL

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	B	DRAWING NO. D3650	REV. C
MFG. APPR.		TITLE	SHEET 7 OF 9
APPROVED		TOP PANEL ASSEMBLY	SCALE
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D3650-5F FLAT PATTERN



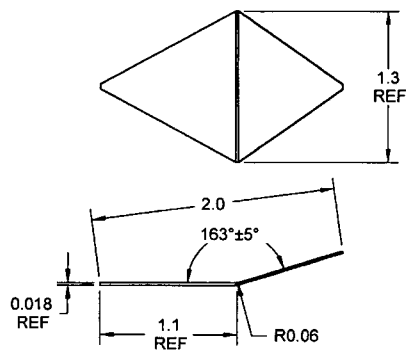
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06/11/17

NOTES:

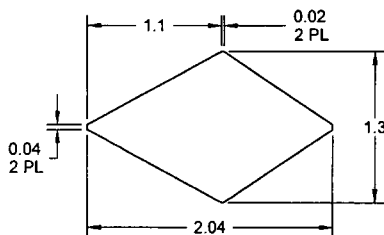
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 LB

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DART
08/10/14

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CHECKED	B	DRAWING NO. D3650	REV. C
MFG. APPR.		SHEET 8 OF 9	
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE
DE APPR.		NTS	
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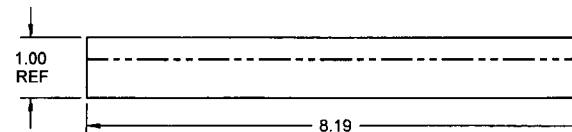
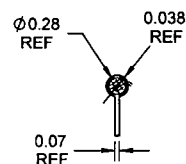
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)



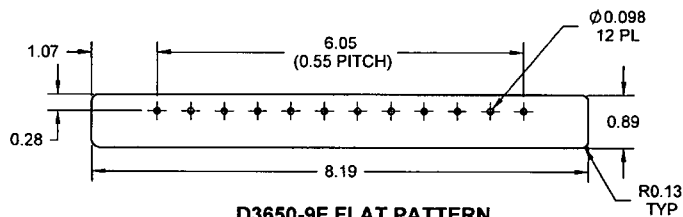
D3650-11F FLAT PATTERN



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
- 8) D3650-11 WEIGHT: 0.007 lb

RELEASED
08/10/14

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3650	REV. C
MFG. APPR.			SHEET 9 OF 9
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE NTS
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DATE	08.10.14		

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